

Work Order ID 77511

77511

Page 1

Monday, December 12, 2011 8:04:46 AM

Item ID: D3806-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar

Start Date: 12/12/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/13/2011 Req'd Qty: 2.00

2

Customer:

Reference:

11.12.13

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3806

B

100

0.00

100

11/12/12

Cold Saw

Memo

0.00

2

Hyd Mech

Out blanks at 49.70"

110

0.00

110

11/12/12

HAAS 1

Memo

0.00

2

HAAS CNC vertical machine #1

1-Mill as per folio FB070 & dwg

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

Manual Mill

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Page 2

Item ID: D3806-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 12/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/13/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>11/12/12</i>		<u>2</u>			
130 *130* QC Quality Control	QCS- Inspect parts - second check Memo	0.00 0.00		<i>11/12/12</i>		<u>2</u>	<u>0</u>		
133 *133* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch. _____ Memo 1- On D3806-3, fill cut outs with hardcoat welding rod as per dwg D3805 2059 B Hardcoat Welding Rod BATCH# <u>M119615</u>	0.00 0.00				<u>2</u>	<u>MA/EL</u>	<u>11/12/12</u>	

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Item ID: D3806-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 12/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/13/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 *136* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<i>11/12/13</i>			
137 *137* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>8 u/12/13</i>		<i>12</i>			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location <i>u/a</i> Memo	0.00 0.00				<i>11/12/13</i>	<i>12</i>		<i>12/12/13</i>

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NS1

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Item Name: Bar

Start Date: 12/12/2011 Start Qty: 2.00

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2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

11/12/13
MF
11-12-13

Picklist Print

Monday, December 12, 2011 8:04:45 AM

Page 1

Work Order ID: 77511

Parent Item: D3806-3

Parent Item Name: Bar

Start Date: 12/12/2011

Required Date: 12/13/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 dwg DD verified by:EC
 IPP Rev:C 11.10.04 rev.b as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500 304 BAR .500 x 2.50		Purchased	No				f	52.4970		8.6315789			

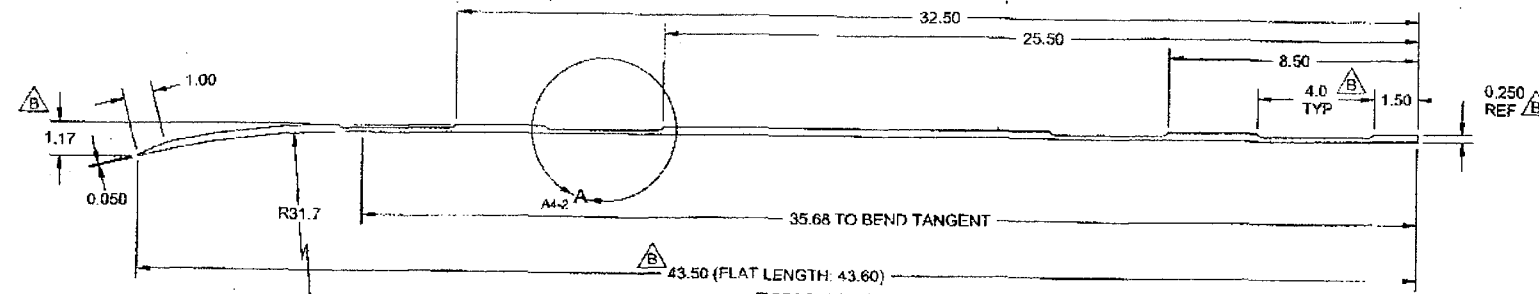
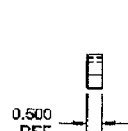
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT050	52.497	
112764	8.312	
116135	0.375	
117685	4.4	
119231	39.41	

M304B 0.5 x .250

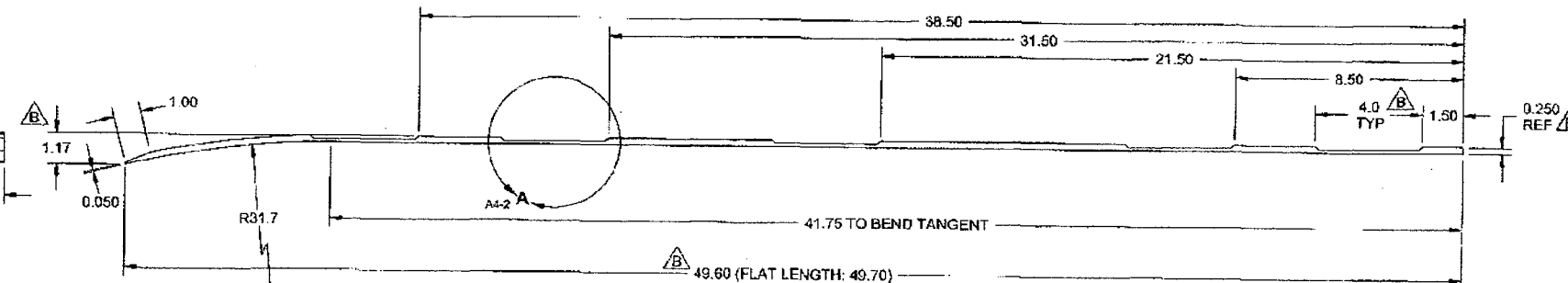
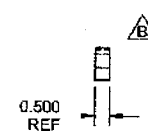
1448972
119872

8.6 f 11/12/12

w/o 77511

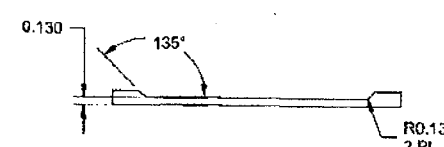


D3806-1 BAR



D3806-3 BAR

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



DETAIL A
TYP, SCALE 2X

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.09.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE TO BE GIVEN TO THE CLOSEST DECIMAL FRACTION THAT IT NOT TO BE RELEASED FOR ANY PURPOSES OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</small>	

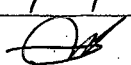

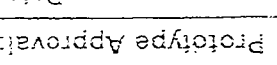
FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD		Work Order: 77511
Description: RAR		Part Number: 3806-3
Inspection Dwg: 3806		Rev: 2
Page 1 of 1		

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1.50	$\pm .030$	1.50	—	—	RA04	Tape
4.00	$\pm .030$	4.00	—	—	"	
8.50	$\pm .030$	8.50	—	—	"	
21.50	$\pm .030$	21.50	—	—	"	
31.50	$\pm .030$	31.50	—	—	"	
38.50	$\pm .030$	38.50	—	—	"	
49.70	$\pm .030$	49.71	—	—	"	
1.00	$\pm .030$	1.00	—	—	"	
1.050	$\pm .010$.060	—	—	RA26	Don
1130	$\pm .010$.128	—	—	"	
1.250	$\pm .010$.256	—	—		
1.500	$\pm .010$.498	—	—		

Measured by: 	Date: 11/2/12	Audited by: 	Date: 11/2/12	Prototype Approval: 	Date: Revised by: Approved: KJ/LM
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